

Work Order ID 63391

Thursday, October 28, 2010 10:52:02 AM



Page 1

Item ID:	D3536-23	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gasket					
Start Date:	10/28/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	11/12/2010	Req'd Qty:	4.00		Customer:	

Reference:

Approvals:	Process Plan:		Date:	10-10-28	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3536	Rev A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3536 <input type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2- Deburr if necessary								

B10-11-2

(8)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B10-11-2

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

8.0.10/10/23

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☐ DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63391

Thursday, October 28, 2010 10:52:02 AM



Page 2

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 10/28/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LP</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

10/11/35 SP 30

10/11/04 MF

10-11-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:52:06 AM

Page 1

Work Order ID: 63391



Parent Item: D3536-23



Parent Item Name: Gasket

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	538.4220	1.3365	5.94	10.7		
NEOPRENE SHEET 0.063											1810-11-2		

Location

Loc Qty

Loc Code

MAT

538.422

115500

138.422

115916

400

115500

⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	63391
Description: Gasket		Part Number:	D3536-23
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85			T B01	
48.20	+/-0.030	48.26			T	
44.70	+/-0.030	44.70			T	
39.31	+/-0.030	39.31			T	
33.92	+/-0.030	33.92			T	
28.53	+/-0.030	28.53			T	
23.14	+/-0.030	23.14			T	
17.75	+/-0.030	17.75			T	
14.25	+/-0.030	14.25			T	
9.50	+/-0.030	9.50			T	
4.75	+/-0.030	4.75			T	
8.00	+/-0.030	8.00			T	
16.00	+/-0.030	16.00			T	
24.00	+/-0.030	24.00			T	
32.00	+/-0.030	32.00			T	
39.00	+/-0.030	39.00			T	
48.00	+/-0.030	48.00			T	
0.30	+/-0.030	.300			V B02	
0.30	+/-0.030	.300			V	
1.89	+/-0.030	1.892			V	
Ø0.19	+0.005/-0.001	.190			V	

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-11-2	Date:	10/11/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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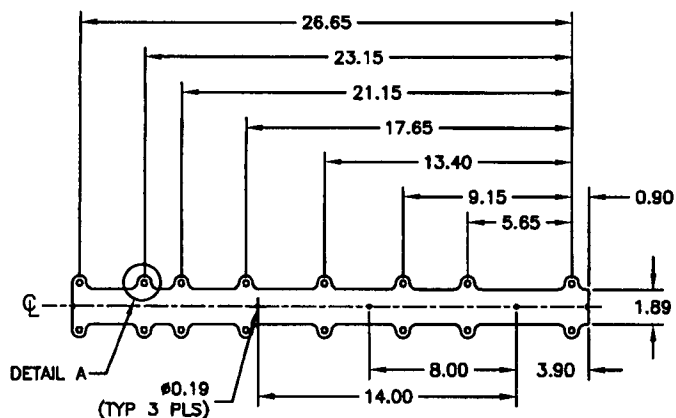
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DART

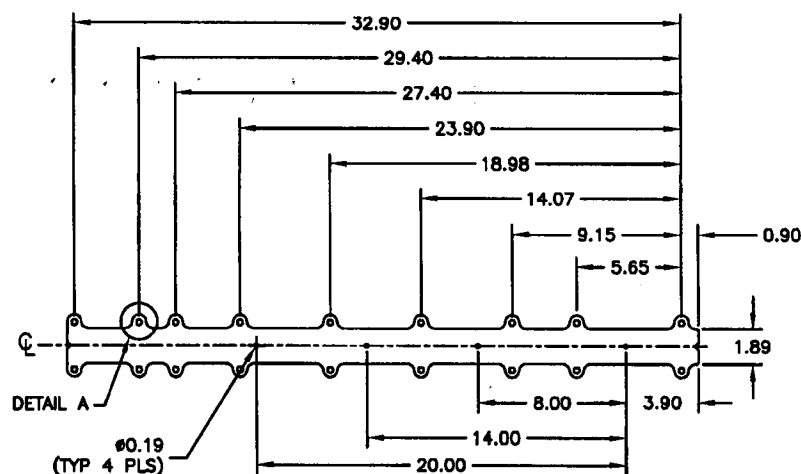
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CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE
		SCALE 1:10

RELEASED
09.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63391
DS 10-10-28



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT Q-Q
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

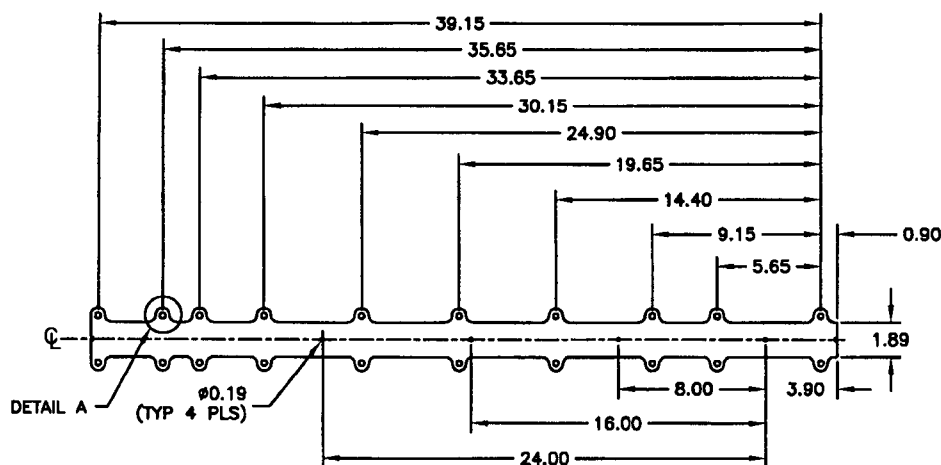
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART

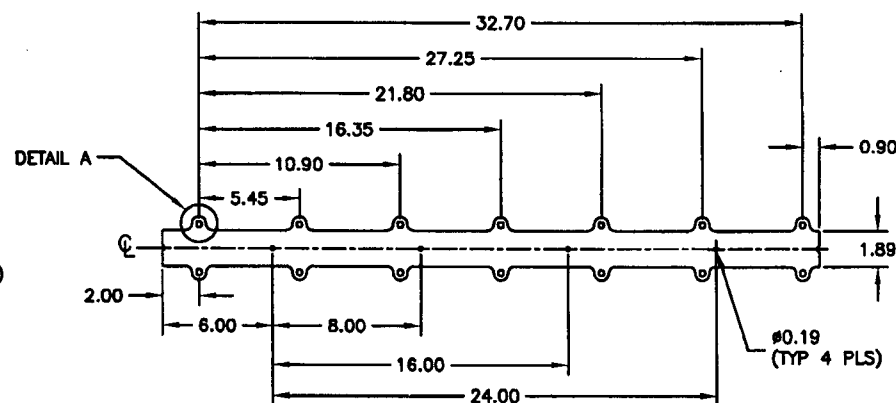
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	GASKET
SCALE	1:10	REV. A	SHEET 2 OF 6	

RELEASED
07.02.12



D3536-15 GASKET

wb 63391



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

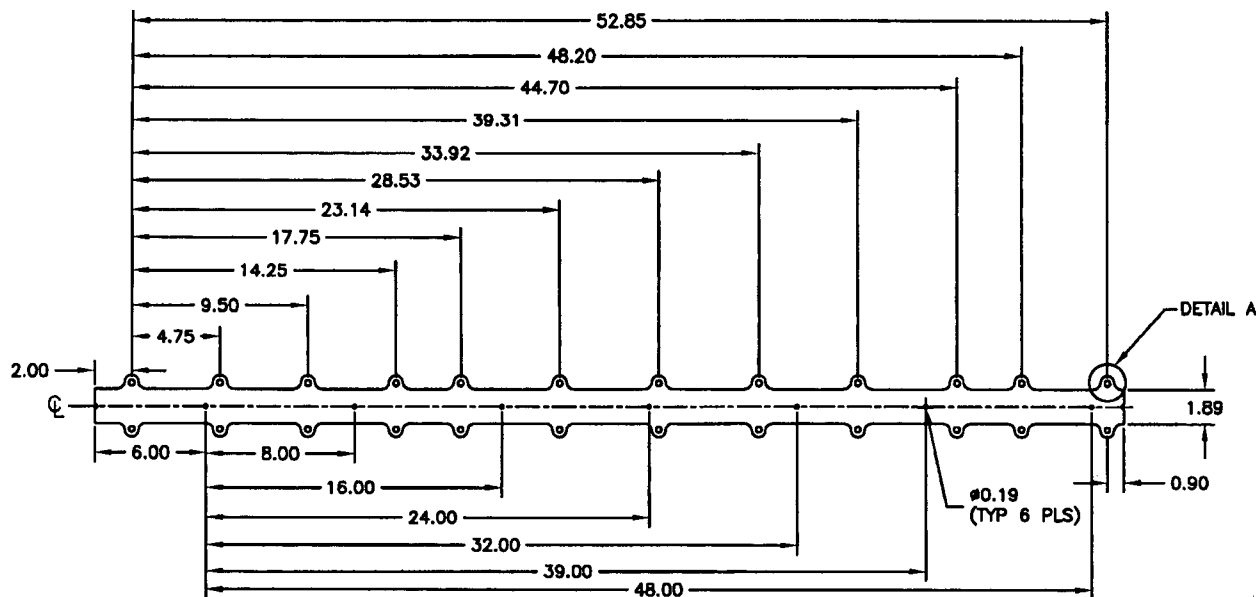
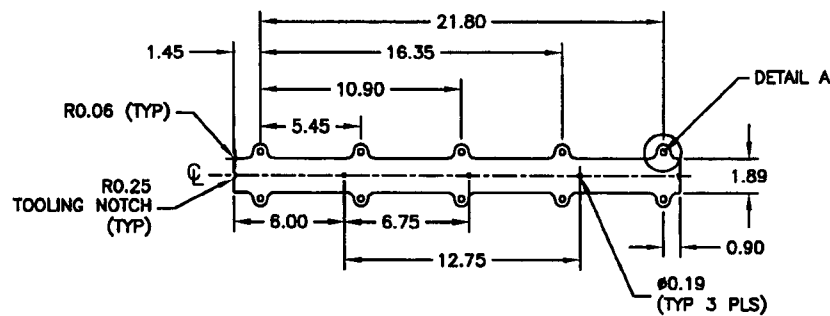
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. A
CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 3 OF 6
CH	CH	D3536	
DATE	TITLE	SCALE	
06.10.25	GASKET	1:10	

**D3536-23 GASKET***26 43391***D3536-25 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

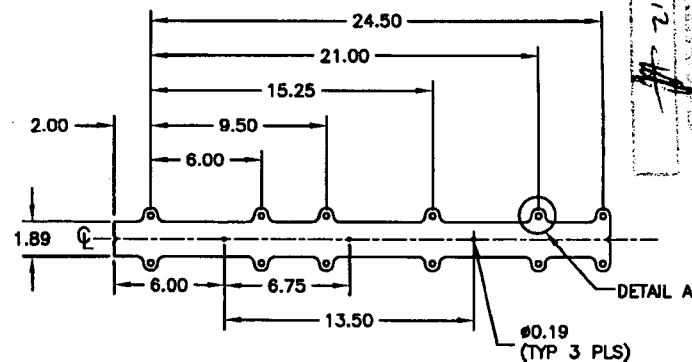
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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DART

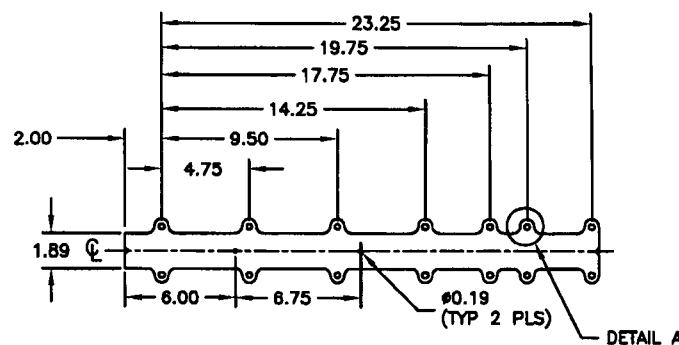
DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	AM	APPROVED	AM	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 4 OF 6
				SCALE 1:10

07.02.12

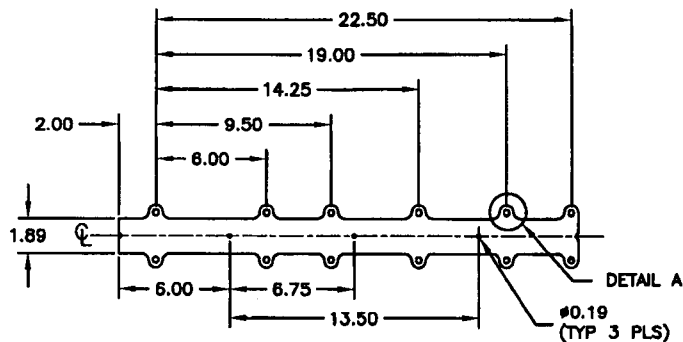


D3536-33 GASKET

W/O 43891



D3536-35 GASKET



D3536-31 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

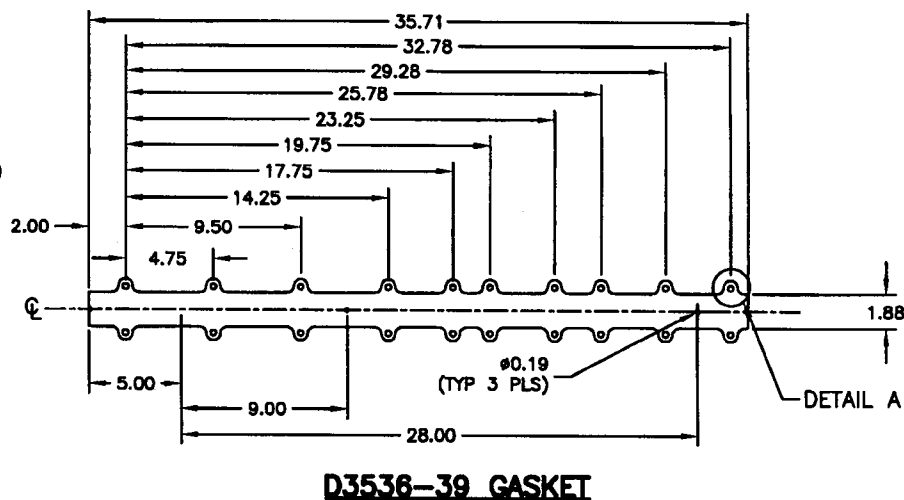
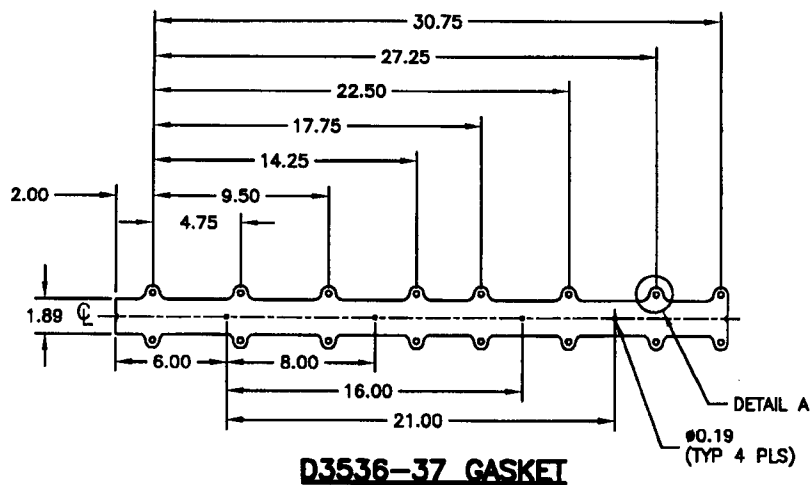
NOTE: Date & initial all entries

DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10

07.02.02
07.02.02
07.02.02

W6 43391



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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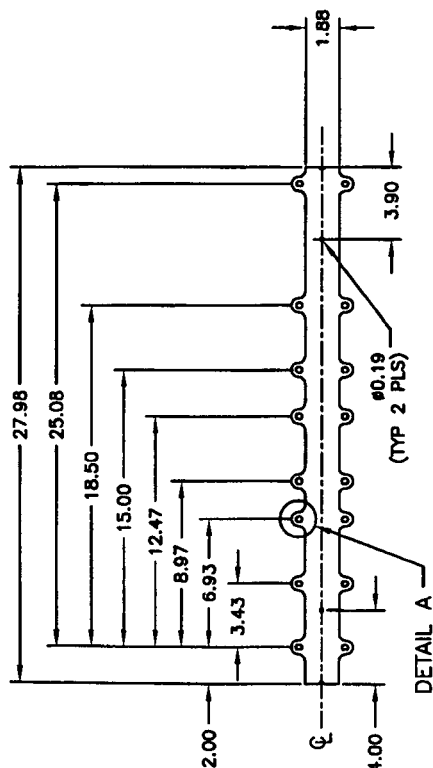
NOTE: Date & initial all entries

DART

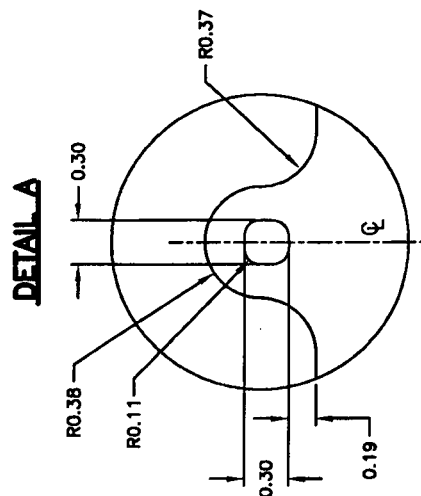
DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A SHEET 6 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10

RELEASED
07.02.12 *[Signature]*

w/b C3391



D3536-41 GASKET



- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.083)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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W/O:		WORK ORDER CHANGES					
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